Qty:

Um:

Each

: DOOR ASSEMBLY

: D32131

:NIA

: 2/19/2007

: N/A

. D3213 REV A

Monday, 2/12/2007 4:16:27 PM

User:

**Process Sheet** 

**Drawing Name** 

**Part Number** 

Material

Due Date

**Drawing Number** 

**Project Number** 

**Drawing Revision** 

Customer

: CU-DAR001 Dart Helicopters Services

Type

S.O. No. : 1) 1A

Job Number **Estimate Number**  : 30656

: 10711

P.O. Number

: N/A

, ; 2/12/2007 This Issue

Prsht Rev.

: N/A First Issue : 30656 **Previous Run** 

Written By

Checked & Approved By

Comment

: Est Rev:A Est Rev:B

New Issue 05-11-17 JLM

: SMALL /MED FAB

Now on Waterjet 07-02-13 JLM

**Additional Product** 

Job Number:



Seq. #:

Machine Or Operation:

**Description:** 

M2024T3S063 1.0



0.4950 sf(s)/Unit Total: 3.9598 sf(s)

Comment: Qty.: Material: 2024-T3 (QQ-A-250/4) 0.063" thick (M2024T3S.063)Identify as D3213-1

Batch: <u>H</u>/02942

2.0

WATER JET

FLOW WATER JET

2024-T3 .063 sheet



Comment: FLOW WATER JET

QC2 3.0



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SECOND CHECK



Comment: SECOND

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

HAND FINISHING

HAND FINISHING RESOURCE #1



6.0

4.0

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 A



Monday, 2/12/2007 4:16:27 PM Dafe: User: Linda Lacelle **Process Sheet Drawing Name: DOOR ASSEMBLY** Customer: CU-DAR001 Dart Helicopters Services Job Number: 30656 Part Number: D32131 Job Number: **Description:** Seq. #: **Machine Or Operation:** INSPECT POWDER COAT/CHEMICAL CONVERSION 7.0 QC3 8x Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE #1 8.0 Comment: PACKAGING RESOURCE #1 x4 Identify and Stock Location: GA QC21 9.0 Comment: FINAL INSPECTION/W/O RELEASE Job Completion U 020223

<b>W</b> /O:				breca	WOF	RK ORDER C	HANGES					
DATE	STEP	*3		PROCE	DURE CHANG		TIANGEO	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
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¥ .												
				; ,								
1			·	·		·			#3.7w/ww			
Part No	:		PAR #: _	·	Fault Catego	ory:	NO	R: Yes	No DQ	A:	Date:	
1 6		·						QA: N	/C Close	d:	_ Date: _	
NCR:				WO	RK ORDE	R NON-CONF	FORMANC	E (NCF	<b>R</b> )			
÷ ,	STED	Descri	ption of NC		C	orrective Action	Section B		Verifi	cation	Approval	Approval
NCR:	STEP	<b>Descri</b> S	ption of NC ection A				Section B	Sign 8	Verifi	<b>cation</b> ion C	Approval Chief Eng	Approval QC Inspecto
÷ ,	STEP	<b>Descri</b> S	ption of NC ection A		Co	orrective Action Action Desc	Section B	Sign 8	Verifi			
DATE	STEP	<b>Descri</b> S	ption of NC ection A		Co	orrective Action Action Desc	Section B	Sign 8	Verifi			
DATE	STEP	<b>Descri</b> S	ption of NC ection A		Co	orrective Action Action Desc	Section B	Sign 8	Verifi			
DATE	STEP	<b>Descri</b> S	ption of NC ection A		Co	orrective Action Action Desc	Section B	Sign 8	Verifi			
DATE	STEP	Descri	ection A		Co	orrective Action Action Desc	Section B	Sign 8	Verifi			
DATE	STEP	S	ection A		Initial Chief Eng	orrective Action Action Desc	Section B	Sign 8	Verifi			
DATE	STEP	S	ection A		Initial Chief Eng	orrective Action Action Desc	Section B	Sign 8	Verifi			

Dart Aerospace Ltd. Monday, 2/5/2007 4:02:52 PM Date: Kim Johnston User: **Process Sheet** : DOOR ASSEMBLY **Drawing Name** : CU-DAR001 Dart Helicopters Services Customer : 30656 Job Number : 10711 **Estimate Number** : D32131 Part Number P.O. Number . D3213 REV A **Drawing Number** : 2/5/2007 S.O. No. : This Issue Project Number : N/A : NC Prsht Rev. : A : 2/5/2007 : MACHINED PARTS **Drawing Revision** Type First Issue : 25260 Material Previous Run Qty: 8 Um: Each : 2/23/2007 **Due Date** Written By Checked & Approved By 05-11-17 JLM : Est Rev:A New Issue Comment **Additional Product** Job Number: Description: Machine Or Operation: Seq. #: 2024-T3 .063 sheet M2024T3S063 1.0 Comment: Qty.: 0.4950 sf(s)/Unit \ Total: 3.9598 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.063" thick (M2024T3S.063)Identify as D3213-1 SHEAR 2.0 SHEAR Comment: SHEAR Cut blanks: 15.100" x 4.500" (+0.000/-0.010) . MACHINING #1 3.0 HAAS1 Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine D3213-1 as per Folio FA350 and Dwg D3213 Stack of 4 INSPECT PARTS AS THEY COME OFF MACHINE 4.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK 5.0 QC8



Comment: SECOND CHECK

## **Dart Aerospace Ltd**

W/O:			WORK ORDER CHANGES					
DATE	STEP PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Category:	NCR: Yes	No DO	Δ.	Date:	I

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_

NCR:		,	WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Verification	A = = = = = 1	A			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector			
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NOTE: Date & initial all entries

Date:

Monday, 2/5/2007 4:02:52 PM

User:

Kim Johnston

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Part Number: D32131

Job Number: 30656

Seq. #:

Job Number:

Machine Or Operation:

Description:

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1





Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



## **Dart Aerospace Ltd**

W/O:		WORK ORDER	CHANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
<del>.</del>							
			4				
Part No	•	PAR #: Fault Category:	NCR: Ye	s No DQ	Α:	Date:	

QA: N/C Closed: \_\_\_\_ Date: \_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Verification	Annroyal	Annroyal		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector		
								·		
							!			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30656
Description: Door Panel	Part Number:	D3213-1
Description. Boot 1 and		
Inspection Dwg: D3213 Rev: A		Page 1 of 1

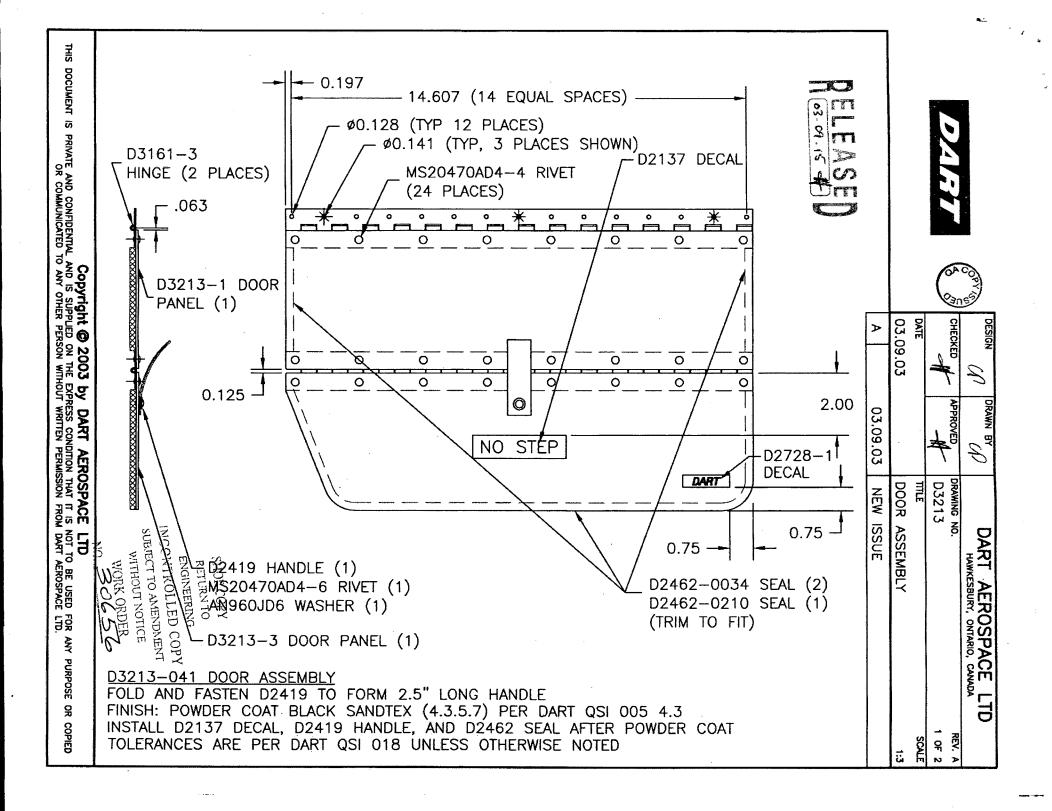
## FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype	
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
15.00	+/-0.030	15.00	V		M-T	
4.47	+/-0.030	4.480			Vern	
14.400	+/-0.005	14,400	V		M-T	
0.300	+/-0.010	0.304			Very	
0.128	+0.005/-0.000	0.304			Vern	
Pitch 2.057	+/-0.005	2,061			Vern	
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Measured by:	SAO	Audited by: 5.1	Prototype Approval:	N/A
Date:	07/07/8	Date: 07/02/18	Date:	N/A

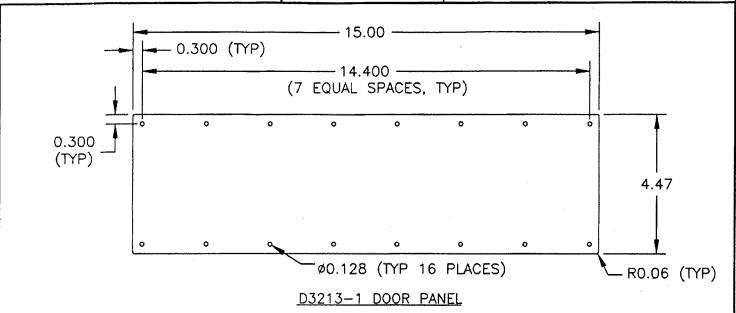
Rev	Date	Change		Revised by	Approved
Α	03.12.15	New Issue	P/O D350-567-015/-025/-031	KJ/RF	<u> </u>

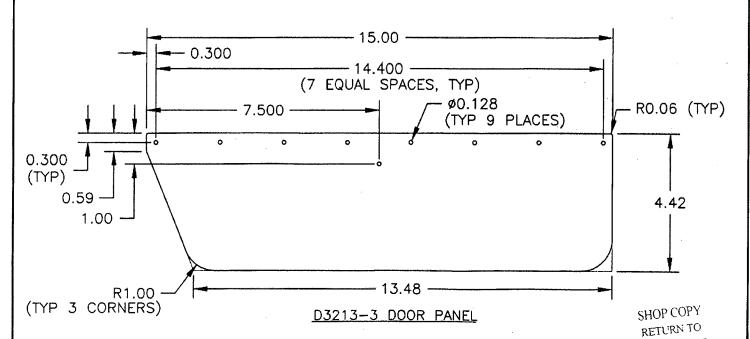






<i>~</i>	DESIGN (1)	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
(2)	CHECKED AL	APPROVED	DRAWING NO.	REV.	Ā
y	de	AF	D3213	2 OF	2
٠	DATE	<u> </u>	TITLE	SCAL	Ε
	03.09.03		DOOR ASSEMBLY	1:	3





D3213-1 AND D3213-3

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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